120

OC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

3

June-03-13 7:22:54 AM Item ID: D3196-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bar **Start Date:** 6/03/13 Start Oty: 6.00 Cust Item ID: Required Date: 6/10/13 Req'd Qty: 6.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13-06-03 Tooling: Approvals: Stop QC: ____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp **Revision Nbr** Draw Nbr D3196 Rev C 100 0.00 BAND SAW *100* Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blank: (0.75" x 1.50") x 26.200" long Bar 110 0.00 HAAS CNC VERTICAL MACHINING #1 *110* HAAS 1 0.00 Memo HAAS CNC vertical machine #1 1-Machine D3196-1 as per Folio FA339 and Dwg D3196Identify as D3196-12-Deburr

0.00

0.00

13/06/06

DQA:		_ Date:			-							DART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / L		Work Order u	pdate only	AEROSPACE
Work Order				`	DISPOSITION				AGAINST	DEPARTMENT	/PROCESS	
Part No	D				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			<u> </u>	Desc	ription of work order update	1	Initial	Δ	ction	Sign &	•	T
Cause	Date	Step	Qty		or non-conformance	1	nief Eng	1	cription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved									,			
			•			FA	ULT CAT	TEGORY				
Landing	Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Tre Inspection Marks/C	at on Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	ion Incomplete/Uions Incomplete, ned/off center	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tv	vist in Tub	e e		Fit/Function		Out of s	Sequence				

Cust Item ID:

Date:

Tool # Plan

Code

Customer:

Tool ID

June-03-13 7:22:55 AM Item ID: D3196-1 Accept *N900040100* **Revision ID:** Item Name: Bar **Start Date:** Start Qty: 6.00 6/03/13 Required Date: 6/10/13 Req'd Qty: 6.00 Reference: Process Plan: Date: Tooling: Approvals: QC: _____ Date: ____ SPC (Y/N): _____ Date:____ Sequence ID/ Operation Set Up/ Work Center ID Description **Run Hours** 130 QC8- Inspect parts - second check 0.00 *130* QC 0.00 Memo Quality Control 140 Chemical Conversion Coat per OSI005 4.1 0.00 *1*4***0*** HandFinish 0.00 Memo Hand Finishing 150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 *150* Powdercoat 0.00 Memo Powder Coating START TIME: OVEN TEMPERATURE: FINISH TIME:

Accept Reject Reject Insp. Qty Qty Number Stamp 6 \$ \$ 13.6-10. 6Xx m-f 13/06/10

Setup Start

Run

mialaza

DQA:			Date:			_							74	
						WORK ORDER NON	-C(ONFO	RMANCE / UI					AEROSPACE
QA Closed:			Date:								Work Order u	pdate only	\Box	
Work Orde	er:					DISPOSITION	į			AGAINST	DEPARTMENT	/PROCESS		
	-					Rework]		Skid-tube	Crosstube	\neg	Water Jet		Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	\square	Quality
	•					Use-as-is		Therr	moforming	Finishing		re/Packaging	П	Other
NCR I	۷o. ₋					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		I Initial	Act	ion	Sign &		П	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	n	QC Inspector
Design													\exists	
Doc/Data														
Equip/Tooling	Щ										-			,
Handling/Pre	Ш													
Material	Ц													
Operator	Ц	•												
Offset/Setup														
Process	Н												ł	
Supplier	$\vdash \vdash$													
Training	$\vdash \vdash$													
Transport	Н													
Unapproved			1	i		,	ΕΛΙ	III T CAT	I TEGORY			<u> </u>		
Landi	ng G	ear				General	IA	OLI CA	ILGORI		· · · · · · · · · · · · · · · · · · ·			
	_	Bending				Bend		Teolio/F	Program	ſ	Outside Din	nensions		Pressure/Forced
	\vdash	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	H	Grain		 	Over/Under		-	Set-up
	Н	Cracks				Broken/Damage/Defect	Г	Hardwa	ıre		Part Incorre		-	Temperature/Cure
	П	Crimp/Kir	nk/Ripple,	/Wave		Burrs		4	ion Incomplete/Un	gualified	Part Lost/M		\vdash	 Weld
:	П	Cuffs				Contamination		i '	ions Incomplete/U	·	Part Moved	_	\Box	Wrong Stock Pulled
		Crushing				Countersink		-1	ned/off center		Positioned	ا Wrong		-
		Heat Trea	it			Cut Too Short		Mislabe		ļ	Power Loss,	/Surge	\Box	Other
		Inspection	n Strip in	Tube		Drawing		Misread	t	•				
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of (Calibration					
	1 1	Wave/Tw	ist in Tuh	<u>م</u>	1	Fit/Function	1	Out of	Saguanca					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

102560

Page 3

June-03-13 7:2	2:55 AM					,
Item ID: Revision ID: Item Name:	D3196-1 Bar		Accept	*N900040	າ1ດ(O* Setup Start *NS1* Stop *NS2*
Start Date: Required Date: Reference:	6/03/13 6/10/13	Start Qty: 6.00 *6* Req'd Qty: 6.00 *6*		Cust Item ID: Customer:		TUCY
Approvals:	Process P	lan: Date:	Tooling:	Date:		Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop *NR2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo	Set Up/ Run Hours 0.00	Tool ID Tool	# Plan Code	Accept Reject Reject Insp. Qty Qty Number Stamp (3(06/10)
170 *170* Packaging Packaging		Identify as per dwg & Stock Location: Memo	0.00	· • • • • • • • • • • • • • • • • • • •		Lax
1 A \^ QC Quality Control		QC21- Final Inspection - Work Order Release Memo	0.00	1		13/6/17/
						0113-04-13

DQA:			Date:						_					Ì	™DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPD		Work	Order ur	odate only		AEROSPACE
Work Orde	ar:				·	DISPOSITION				AGAINST I		·			
Work Orde	er					Rework	1		المطينة لمزيا	C	\neg		Water Je		l
Part N	do.					Scrap	1		₩	Crosstube Small Fab	\dashv	Pro	d. Eng. Coor	-	Engineering Quality
raiti	' '					Use-as-is			noforming	Finishing	-		u. Eng. Coor re/Packaging	_	Other
NCR N	No	<u>.</u>				Suspected Unapproved]	1110111	~ ⊢ —	Composite		Nec/3tor	Supplie		
Root		-			Descr	ription of work order update		Initial	Action			Sign &	. <u> </u>		
Cause	D	ate	Step	Qty		or non-conformance	1	nief Eng	Descript			Date	Verification	on	QC Inspector
Design			·········					, 0	· · · · · · · · · · · · · · · · · · ·						
Doc/Data															
Equip/Tooling															
Handling/Pre											1				
Material															
Operator ,															!
Offset/Setup															
Process															
Supplier															
Training	Ш														
Transport															
Unapproved .				i		-	<u> </u>								
	<u> </u>						FA	ULT CAT	regory				 		
Landii	ng Gear					General]		Г					l_
	— i	iding	. Camaaa			Bend BOM/Bouts	⊢	-{	rogram			utside Dim		\vdash	Pressure/Forced
	Cra		t Concer	TUTIC		BOM/Route Broken/Damage/Defect	\vdash	Grain			_	/er/Under		\vdash	Set-up
	\vdash		k/Ripple	Maya			\vdash	Hardwa		alified	_	rt Incorrec		\vdash	Temperature/Cure
	Cuf		k) wibbie	/ wave	\vdash	Burrs Contamination	-	1	on Incomplete/Unquions Incomplete/Unc			rt Lost/Mi	ssing	\vdash	Weld
	_	shing			-	Countersink	\vdash	4	ned/off center	lear		sitioned W	Vrong	L_	Wrong Stock Pulled
		silling it Treat	•		-	Cut Too Short	\vdash	Mislabe		-	_	wer Loss/S	_		Other
	_		Strip in	Tuhe		Drawing	-	Misread		Ĺ		WEI LUSS/3	Juige	<u> </u>	Otilet
		rks/Cha		·ubc		Drill Holes	\vdash	Off-set	4						
	_		equence			Finish	\vdash	1	Calibration				_		
	_	-	st in Tub			Fit/Function		-	Converse						*

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID: 102560

D3196-1

Parent Item Name: Bar

102560

D3196-1

Start Date: 6/03/13

Required Date: 6/10/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

Parent Item:

IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50		Purchased	No			100	f	32.8350	2.183	13.7873 13.(2	5		

M6061T6B0 750X01 500

•		**	· 27 13-06-05
Location	Loc Qty	Loc Code	
MAT049	32.835		
122753 K	8.835		8.75
m125771	24		4.325

DQA: Date:								_				™ ∆ART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		Vork Order u	odate only	AEROSPACE
Work Orde	r·				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIR Olde	'			_	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				_	Use-as-is		Therr	noforming	Finishing		re/Packaging	Other
NCR N	lo	<u>.</u>			Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desci	ription of work order update		Initial	Actio	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Design												
Doc/Data	_											
Equip/Tooling								:				
Handling/Pre												
Material											-	
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												
						FA	ULT CA	TEGORY				
Landir	ng Gear			_	General		-		_	_		_
	Bending				Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
	Cuffs			L	Contamination		Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
	Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread	d	_			
	Marks/Cl	hatter			Drill Holes		Off-set					
	Turning S	Sequence			Finish		Out of (Calibration				
	Wave/Tw	vist in Tub	oe .		Fit/Function		Out of	Seauence				

DART AEROSPACE LTD	Work Order:	002501
Description: Bar	Part Number:	D3196-1
Inspection Dwg: D3196 Rev: C		Page 1 of 1

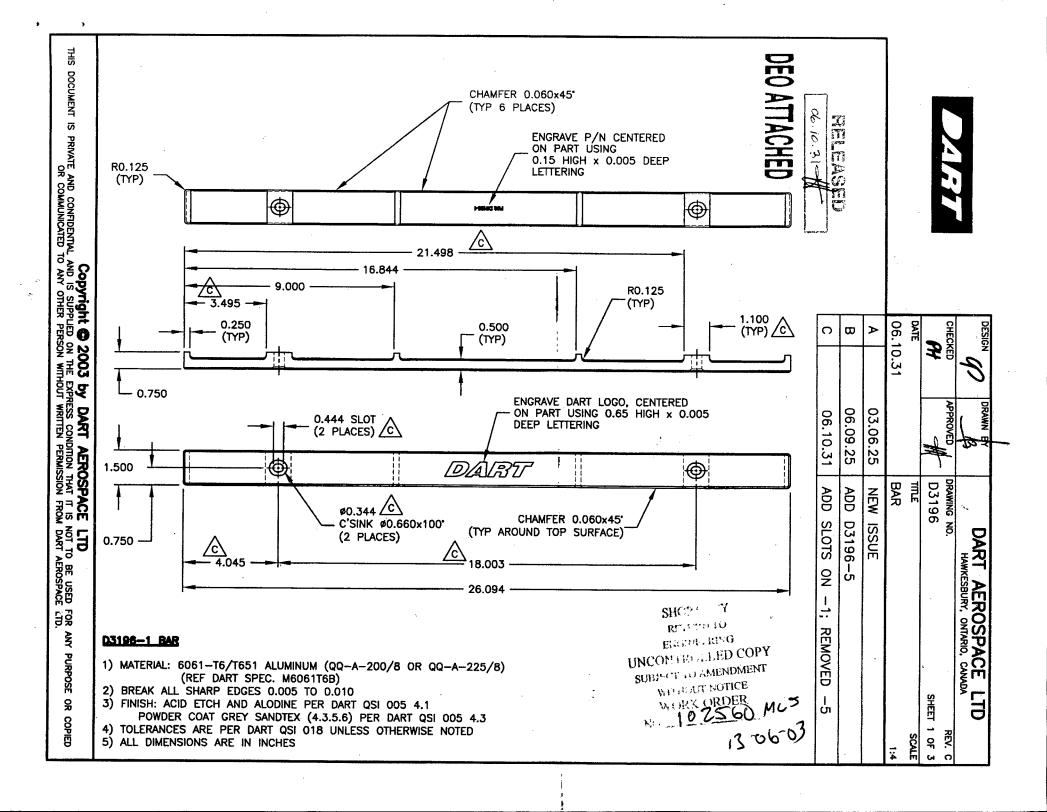
FIRST ARTICLE INSPECTION CHECKLIST

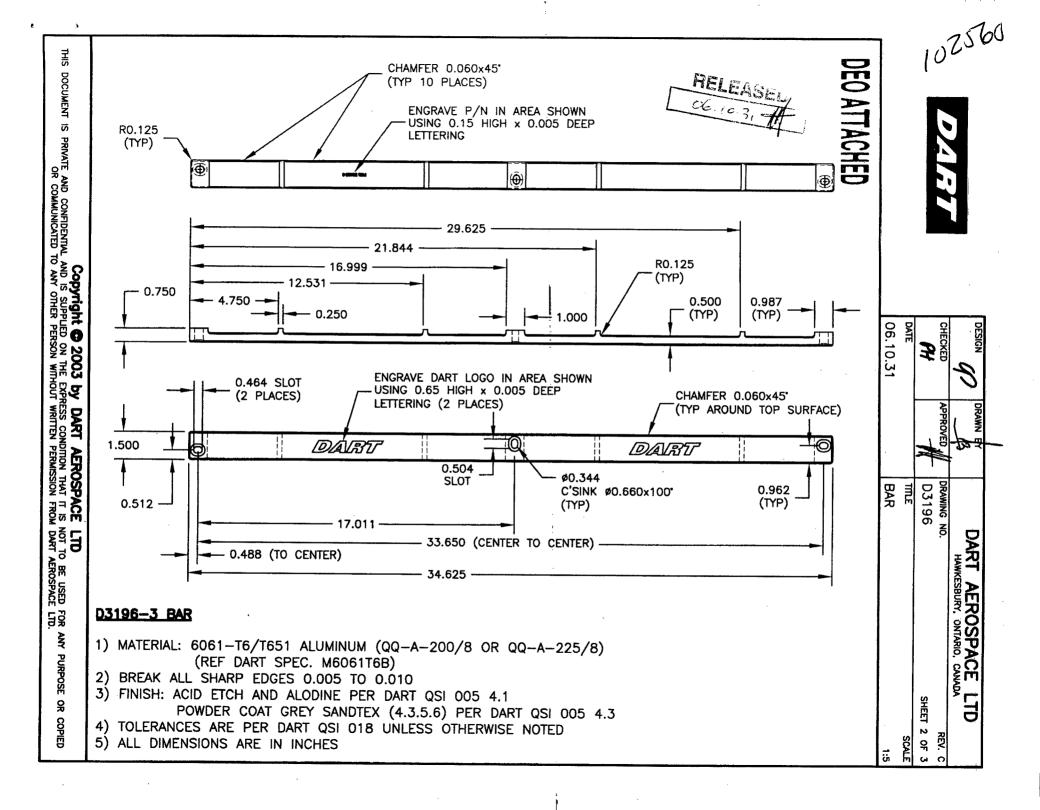
X First Article Prototype

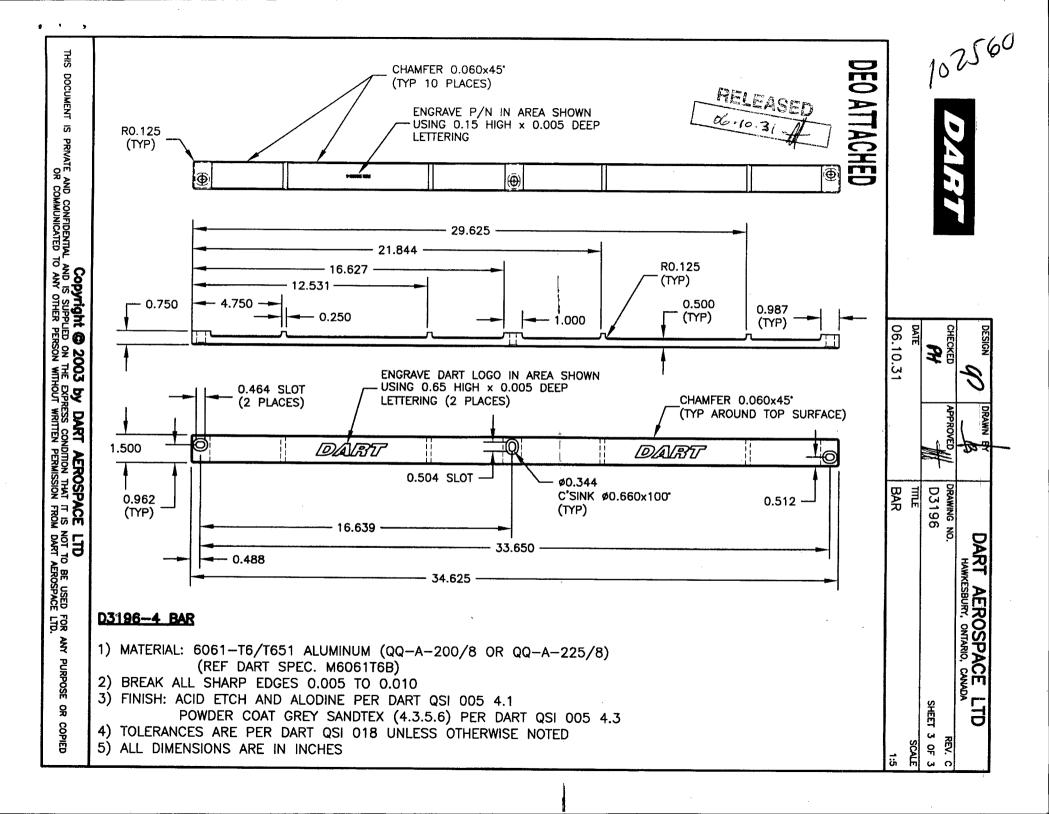
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.094			1435 Z	
4.045	+/-0.010	4.045	1		VERN	P40-12
18.003	+/-0.005	18.003	V		MASS	
0.750	t.010+1-0.005	.745			VERN	PND-12
1.500	+/-0.010	1,495	/		61	^
Ø0.344	+0.006/-0.001	. 345	/		1.0	4
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	-665	/	-	1.	**
0.060 x 45°	+/-0.010 x 0.5°	. 060	V	·	u	e.
0.750	+/-0.010	.745	/		11	٧.
0.250	+/-0.010	.251	/	- 	14	11
3.495	+/-0.010	3,488	1		**	۵,
9.000	+/-0.010	9,000			M Tape	PHO-11
16.844	+/-0.010	16,844			1	41
21.498	+/-0.010	21498	~		l.	· 11
R0.125	+/-0.010	.125			Rad G.	
1.1 00	+/-0.010	1,100			VERW	PHD-12
R0.125	+/-0.010	, 125			11	"
0.444	+/-0.010	. ५५५			K	26
	- 1800					<u> </u>
	l			I		

Measured by: PD	Audited by:	St	Prototype Approval:	N/A
Date: 13/06/06	Date:	13-06-07	Date:	N/A

Rev	Date	Change	Revised by Appre	oved
L A	04.04.20	New Issue	KJ/RF	
В	06.10.24	Dwg Rev. updated	KJ/JLM , ,	
С	07.03.21	Dimensions updated per Dwg rev. C	KJ/JLM A	Z

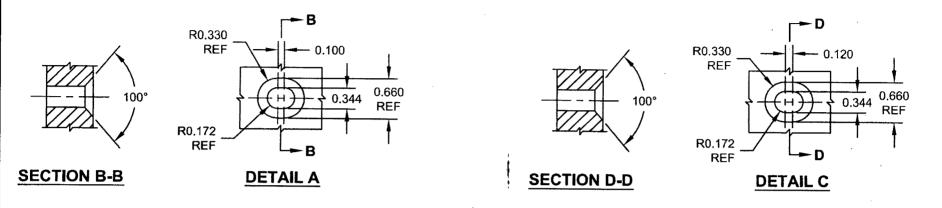






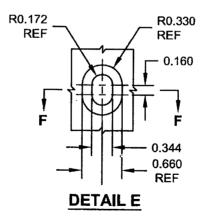
DRAWING NO. TITLE DART AEROSPACE LTD REV. C D.E.O. NO. SHEET NO. SCALE D3196 BAR **ENGINEERING ORDER** D3196-C-1 SHEET 1 OF 2 NTS DRAWN AS5 CHECKED MFG. APPR. **APPROVED** DE APPR. DATE 08.08.27 DATE 08.08.28 08.09.04 DATE 08.08.29 DATE 08.08.29 DATE SHEET 1 MODIFY SLOT DIMENSIONING ON D3196-1 AS SHOWN: IS: **((** DART D3196-1 BAR 0.444 SLOT WAS: (2 PLACES) ⊕ DART Ø0.344 C'SINK Ø0.660x100° D3196-1 BAR (2 PLACES) SHEET 2 MODIFY SLOT DIMENSIONING ON D3196-3 AS SHOWN: IS: 0 DAVET DAVET **D3196-3 BAR** WAS: 0.464 SLOT (2 PLACES) DAVETT HQ. 0 DAST 0.504 - Ø0,344 C'SINK Ø0.660x100° SLOT (TYP) D3196-3 BAR SHEET 3 MODIFY SLOT DIMENSIONING ON D3196-4 AS SHOWN: IS: DAY37 DAVET D3196-4 BAR WAS: 0.464 SLOT (2 PLACES) DAVET DAVET 0.504 SLOT Ø0.344 C'SINK Ø0.660x100° (TYP) D3196-4 BAR COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DATA PERFOSPACE LTD.

DDAMING NO	T.T. F									
DRAWING NO.	TITLE		REV. C	DART AEI	ROSPACE L	. TD D.E.O. NO) <u>.</u>	SHE	ET NO.	SCALE
D3196	BAR			ENGINEE	RING ORDI	ER D3196-0	C-1 .	SHEE	7 2 OF 2	NTS
DRAWN	1 15	CHECKED		MFG. APPR.	91	APPROVED	160	DE APPR.	#	
DATE 08.0	8.27	DATE	08.08.28	DATE	08.08.29	DATE	08.08.29	DATE	08.09.00	f





SECTION F-F



NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS SEE NCR 08-051 FOR FURTHER INFORMATION ALL OTHER INFORMATION REMAINS UNCHANGED

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